

Work Order ID 160944

Friday, May 05, 2017 10:21:12 AM

160944

Page 1

Item ID: PB67-43001-79

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Blade Support Assembly

Start Date: 5/11/2017 Start Qty: 14.00

14

Cust Item ID:

Required Date: 5/18/2017 Req'd Qty: 14.00

14

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: **DAS**Date: **21**

Tooling:

Date:

Run Start ***NR1***QC: **21**Date: **9-89**

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001	C

100 Weld per dwg A/R Aluminum rod Batch: **131562** 0.00***100***

Large Fab

Memo

3.78

Large Fab

Weld assembly as per dwg PB67-43001
USE DT10018**14/** **JUN 01 2017** **DAS**
24
9-89

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

(14) **170601** **PD**

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.28

Quality Control

(14) **170601** **PD**

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
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Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 <i>MB4092</i> Memo *** put screws in nut plates before to keep thread clean*** START TIME: <i>10:05</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>10:35</i>	0.00 1.73				<i>14</i>	<i>17-06-2</i>	<i>333</i>	
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.14				<i>14</i>		<i>333</i> <i>9-89</i> JUN 05 2017	
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>WAO03</i> Memo	0.00 0.14				<i>14</i>		JUN 05 2017 <i>6</i> <i>9-89</i> DAS	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	1.40							
Quality Control									

JUN 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, May 05, 2017 10:21:11 AM

Page 1

Work Order ID: 160944

160944

Parent Item: PB67-43001-79

PR67-43001-79

Parent Item Name: Lower Blade Support Assembly

Start Date: 5/11/2017

Required Date: 5/18/2017

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ PB67-43001-171 *PR67-43001-171* Mounting Plate		Manufactured	No			100	Each	0.0000	6	84		JUN 0 1 2017	DAS 24 9-89
✓ PB67-43001-177 *PR67-43001-177* Short Support Plate		Manufactured	No			100	Each	0.0000	1	14		JUN 0 1 2017	DAS 24 9-89
✓ PB67-43001-179 *PR67-43001-179* Short Side Plate		Manufactured	No			100	Each	0.0000	2	28		JUN 0 1 2017	DAS 24 9-89

JUN 0 1 2017

DQA: _____ Date: _____

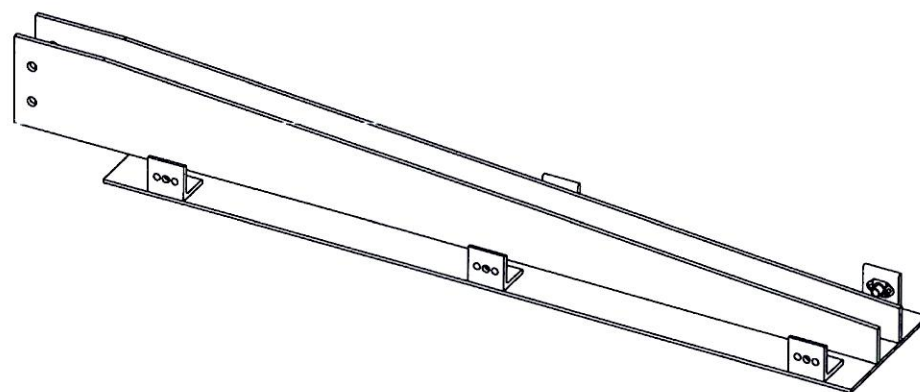


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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B67-43001-79 LOWER BLADE SUPPORT ASSY

ITEM	QTY 79	P/N	DESCRIPTION
1	X	B67-43001-79	LOWER BLADE SUPPORT ASSY
3	6	B67-43001-171	MOUNTING PLATE
4	1	B67-43001-177	SHORT SUPPORT PLATE
5	2	B67-43001-179	SHORT SIDE PLATE
7	12	MS20426AD3-4	RIVET
8	6	MS21075L3	NUT PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 160944 MJS
170505

RELEASED
R 2009-09-24
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-79" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.96 lbs
- 8) WELDING: PER DART QSI 004

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 11 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.26
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. C
MFG. APPR.			B67-43001-79	SHEET 1 OF 2
APPROVED			TITLE	SCALE
DE APPR.	N/A		LOWER BLADE SUPPORT ASSY	NTS
DATE	09.06.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

